Work Order ID 59870

Tuesday, June 15, 2010 1:05:07 PM

Item ID: D2523 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Mounting Braket

Start Date: 6/15/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 6/21/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 10-6-15 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2523	Rev A2								
100		0.00							
Bandsaw	BAND SAW	0.00 MK 10/08/16				2	0		
Jeaspa Bandsaw	**Memo** Cut blank: 21.75" x 12.00"								
110		0.00							
HAAS 1	HAAS CNC VERTICAL MACHINING #1	MK 10/08/16				2	0		
HAAS CNC vertical machine #1	**Memo** Machine as per folio D2523	0.00 LB 10/04/17							
120	QC2- Inspect parts off machine FAI/FAIB	0.00 LB 10/08/17							
QC	**Memo**	0.00				2	0		
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				2			
QC	**Memo**	0.00							
Quality Control									
140		0.00				(2X)			
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
	Deburr□Drill holes as per dwg D2523 using DT8560								
150	QC5- Inspect part completeness to step on W/O	0.00				(2)			
QC	**Memo**	0.00							
Quality Control									

10/08/24

10/08/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00	=) MH	10/08/25		X 2	0		
	Memo	0.00							
170 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	M115291								
	Memo	0.00							
	START TIME: 10:45 ☐OVEN TEMPERATURE: 325 ☐FINISH TIME: 11:15								
	2 BL 10-8-25.								
180 QC Quality Control	QC3- Inspect Part Finish	0.00	=) MH	10/08/25		2	0		
	Memo	0.00							

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 59870

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Item Name: Mounting Braket

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 199	0.00							
Packaging	**Memo**	0.00							
Packaging						10/08/31	(2)		
200	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/08/31

CL 10/8/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 1:05:11 PM

Work Order ID: 59870

Parent Item: D2523

Parent Item Name: Mounting Braket

Start Date: 6/15/2010 **Required Date:** 6/21/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP C□01.04.16□Re format, added DT8560□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.000		Purchased	No			100	f	4.0000	1.8125	3.815789			

6061-T6 Bar 1.00 x 12.00

Location	Loc Qty	Loc Code
MAT05	4	
106701	4	

M115255 1.8125 MR 10/08/16

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59870
Description: Mounting Bracket	Part Number:	D2523
Inspection Dwg: D2523 **Rev:** A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	.258	✓		VERN SF-12	
1.076	+/-0.010	1.078	✓		V SF-12	
1.985	+/-0.010	1.984	✓		✓ SF-12	
Ø0.257	+0.005/-0.001	.258	✓		"	
9.372	+/-0.010	9.377	✓		V CNC-02	
1.035	+/-0.010	1.035	✓		V SF-12	
Ø0.191	+0.005/-0.000	.191			V SF-12	
7.546	+/-0.010	7.551	✓		V CNC-02	
2.776	+/-0.010	2.772	✓		V SF-12	
2.776	+/-0.010	2.772	✓		"	
0.875	+/-0.010	.875	✓		"	
R0.125	+/-0.010	.125	✓		Rad gauge	
1.00	+/-0.030	1.010	✓		VSF12	
R0.125	+/-0.010	.125	✓		Rad gauge	
0.750	+/-0.010	.748	✓		VSF12	
0.250	+/-0.010	.249	✓		"	
R0.250	+/-0.010	.250	✓		Rad gauge	
0.125	+/-0.010	.135	✓		High gauge / Dial	
R0.125	+/-0.010	.124	✓		Rad gauge	
R0.063	+/-0.010	.062	✓		Rad gauge	

Measured by:	BS
Date:	10/05/17

Audited by:	[illegible]
Date:	10.8.17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

Dart Aerospace Ltd

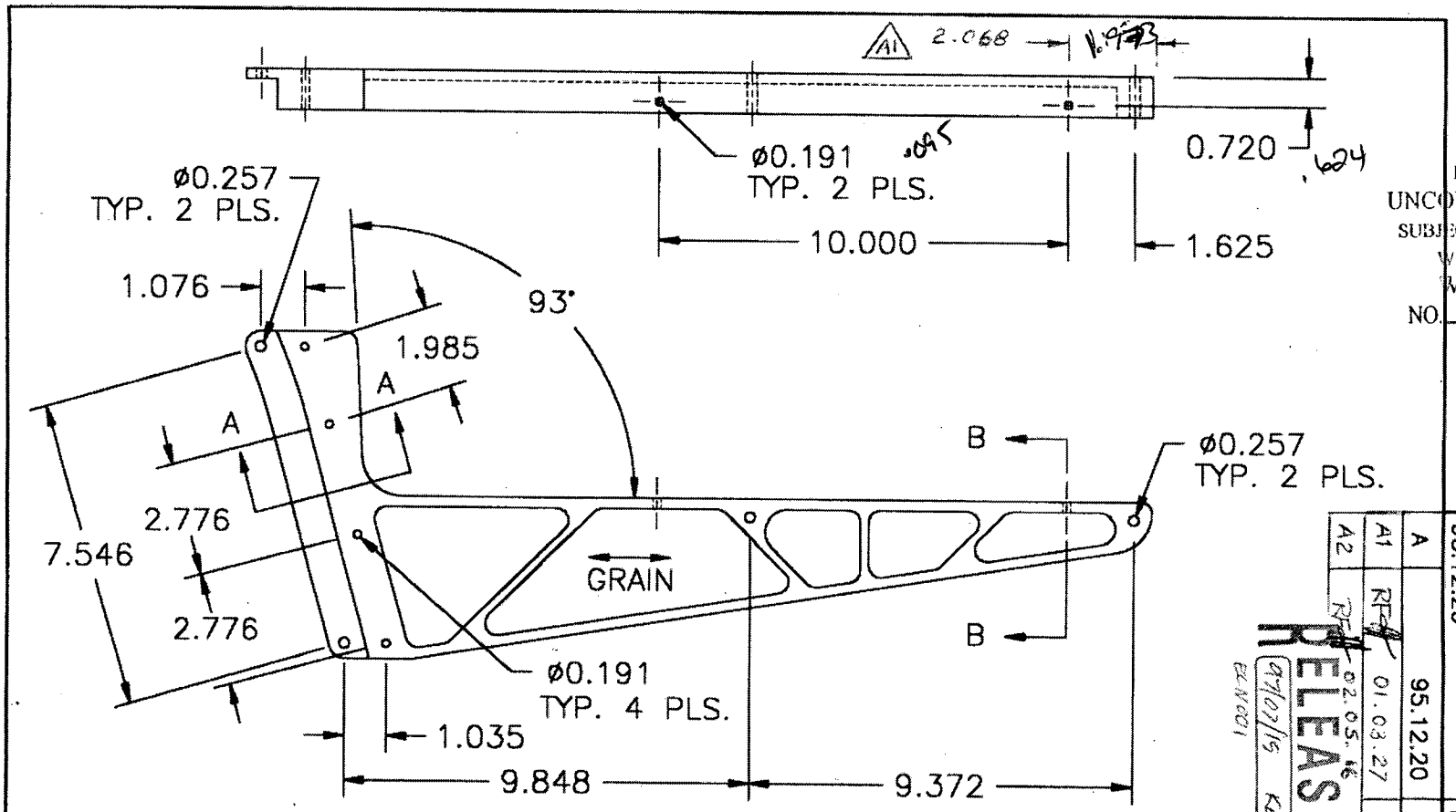
W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

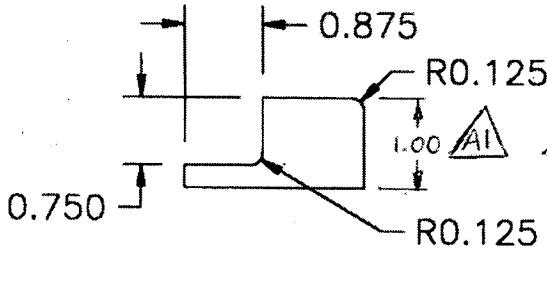
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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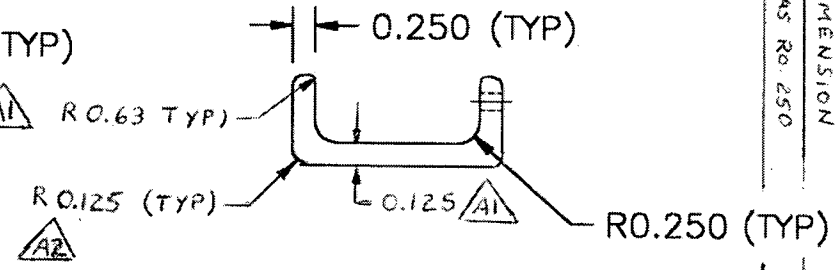
NOTE: Date & initial all entries



SECTION A–A
SCALE 1:2



SECTION B–B
SCALE 1:2



MATERIAL: 6061–T6 QQ–A–200/8 1.00 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

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WORK ORDER NO. 0810615

OLD COPY SUPERSEDED

RELEASED
07/01/15 KE
EC N001

REV	DATE	DESCRIPTION
A	95.12.20	NEW ISSUE
A1	01.03.27	ADDED DIMENSION
A2	02.05.16	R0.125 WAS R0.250

DESIGN: BW
CHECKED:
DRAWN BY: KE
APPROVED:
DATE: 95.12.20

DART AEROSPACE LTD
VICTORIA INTERNATIONAL AIRPORT, CANADA

TITLE: MOUNTING BRACKET
DRAWING NO. D2523
REV. A
SHEET 1 OF 1
SCALE 1:4

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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